

Date: Thursday, 1/17/2008 3:31:33 PM  
 User: Kim Johnston

## Process Sheet

|  |  |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services   | Drawing Name : DOUBLER                 |
| Job Number : 36844                               |  |
| Estimate Number : 10227                          |  |
| P.O. Number :                                    | Part Number : D2151                    |
| This Issue : 1/17/2008 S.O. No. :                | Drawing Number : D2151 REV B           |
| Prsht Rev. : NC                                  | Project Number : N/A                   |
| First Issue : 1 / Type : SMALL /MED FAB          | Drawing Revision : B                   |
| Previous Run : 34467                             | Material :                             |
| Written By :                                     | Due Date : 1/31/2008 Qty: 100 Um: Each |
| Checked & Approved By : <u>JD 08/01/18</u>       |  |
| Comment : Est C 00.10.23 Re-format (mpp 2101) EC |  |
| Est Rev:D 06-04-28 Manufactured on Water Jet JLM |  |
| Est Rev:E 06-11-24 As per Rev B JLM              |  |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0368 sf(s)/Unit Total : 3.6750 sf(s)  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch: 106272 IB 8-1-22

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2151  
 Dwg Rev: B  
 Prog Rev: B

IB 8-1-22

109

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08/01/25 109 cosentes

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

08/01/24 109

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:33 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36844

Part Number: D2151

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AS

08-01-28

X109

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DR

08-01-29

109

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-1

08/01/29

109X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5717

08/01/30

109

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208101/31

Job Completion



u 08/01/31

109

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |  |                     |       |
|--|--|---------------------|-------|
| <b>DART AEROSPACE LTD</b>                |  | <b>Work Order:</b>  | 36844 |
| <b>Description: Packer</b>               |  | <b>Part Number:</b> | D2151 |
| <b>Inspection Dwg: D2151      Rev: B</b> |  | <b>Page 1 of 1</b>  |       |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098            | +0.005/-0.000 | .100             | X      |        |                      |          |
| Ø0.171            | +0.005/-0.000 | .172             | X      |        |                      |          |
| 0.231             | +/-0.010      | .231             | X      |        |                      |          |
| 1.217             | +/-0.010      | 1.218            | X      |        |                      |          |
| 2.194             | +/-0.010      | 2.194            | X      |        |                      |          |
| 2.300             | +/-0.010      | 2.300            | X      |        |                      |          |
| 1.560             | +/-0.010      | 1.560            | X      |        |                      |          |
| 0.250             | +/-0.010      | .250             | X      |        |                      |          |
| 1.328             | +/-0.010      | 1.328            | X      |        |                      |          |
| 0.342             | +/-0.010      | .342             | X      |        |                      |          |
| 0.740             | +/-0.010      | .740             | X      |        |                      |          |
| 2.050             | +/-0.010      | 2.050            | X      |        |                      |          |
| 0.040             | +/-0.010      | .038             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                     |        |                    |             |                            |     |
|---------------------|--------|--------------------|-------------|----------------------------|-----|
| <b>Measured by:</b> | DB     | <b>Audited by:</b> | [Signature] | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 8-1-22 | <b>Date:</b>       | 06/11/25    | <b>Date:</b>               | N/A |

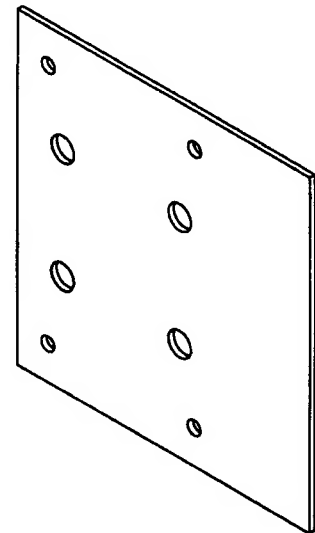
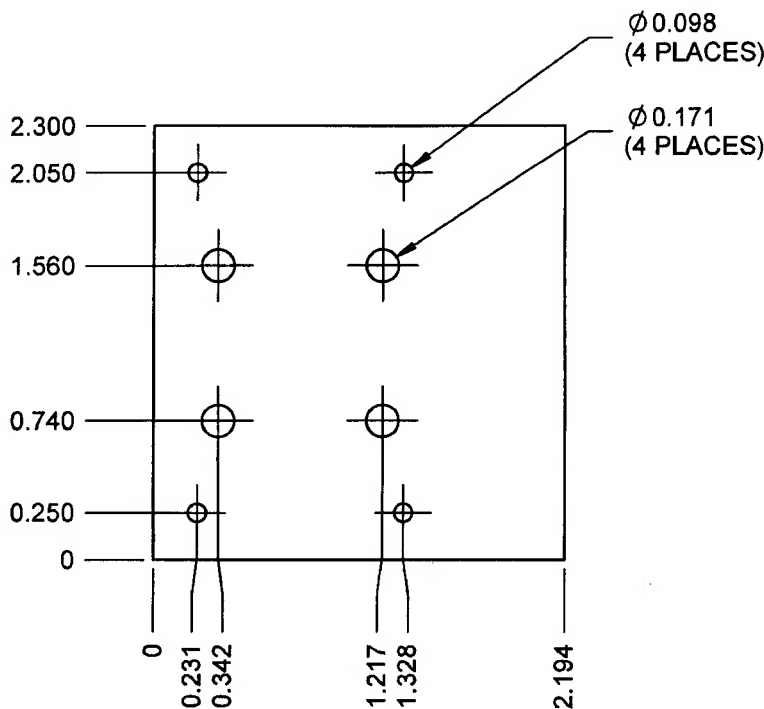
| Rev | Date     | Change               | Revised by         | Approved    |
|-----|----------|----------------------|--------------------|-------------|
| A   | 04.08.12 | New Issue            | KJ/JLM             |             |
| B   | 06.11.24 | Dwg Revision revised | KJ/JLM [Signature] | [Signature] |



|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN<br><b>BW</b>     | DRAWN BY<br><b>CB</b>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><b>LE</b>    | APPROVED<br><b>[Signature]</b> | DRAWING NO.<br><b>D2151</b>                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br><b>06.10.13</b> |                                | TITLE<br><b>PACKER</b>                                   | SCALE<br>1:1           |
| REV                     | DATE                           | DESCRIPTION  |                        |
| A                       | 95.05.01                       | NEW ISSUE  |                        |
| B                       | 06.10.13                       | UPDATE DRAWING   |                        |

**RELEASED**

06.11.20 **[Signature]**



**D2151 PACKER**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **36844**

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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